

Work Order ID 54963

January 5, 2010 11:19:13 AM



Page 1

Item ID: D3562-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Assembly, LH

Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *RL*

Date: 10-1-05

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3562	Rev E

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622 extrusion as per Dwg D3562-02-Deburr and bevel ends for welding

RL 10-01-13

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

⇒ 10-01-13

(4)

Pb3

Quality Control

120

0.00



Chemical Conversion Coat per QS1005 4.1

HandFinish

Memo

0.00

RL 10-01-14

1

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3562-041 PAR #: _____ Fault Category: Large Def NCR: Yes ☐ No ☒ DQA: [Signature] Date: 10-03-01
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>54963</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/1/12	# 100	Qty x1 step FOUND in rack with multiple dents along the top + side. RC. Steps + Trans Port.	<u>[Signature]</u>	Scrap entire length re cut new step	<u>[Signature]</u> 10-01-13	S 10/2/12	<u>[Signature]</u> 10/5/12	S 10/1/12

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00



SAD

(1)

QC

Memo

0.00

10-01-15

Quality Control

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1- Transfer drill Rivet holes as per dwg D3562. 2-Touch-up rivet holes with alodine as per dwg d3562. 3-Rivet legs using Magnabond as per dwg D3562. *****Ensure to wipe off any excess magnabond ***** A/R Magnabond 6398 Batch: m112417

10-01-15

150

QC5- Inspect part completeness to step on W/O

0.00



2/5 10/6/15

QC

Memo

0.00

Quality Control

+1
LH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Setup Start



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Item Name: Step Assembly, LH

Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld end caps as per Dwg D3562 & QSI 004. Inspect for foreign objects as per QSI 024. A/RAuminum Rod M111311 U2-Grind end cap welds flush as per Dwg D3562

PH 10.01.18

1 0

170

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

(1)

BE 10/01/18

180

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

278 10/02/01

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 54963

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Item ID: D3562-041
Revision ID:
Item Name: Step Assembly, LH

Accept



Setup Start



Stop



Start Date: 05/01/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190 Chemical Conversion Coater per QSI005 4.1

0.00



HandFinish

Memo

0.00

7/24 10-02-05

(X) 0

Hand Finishing

200 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

7/24 10-01-08

LH1
(X) 0

Powder Coating

START TIME: 7:15AM OVEN TEMPERATURE:
FINISH TIME: 7:45AM 320°F

210 Pressure Wash per QSI005 4.3

0.00



HandFinish

Wing Walk Batch M113462
Memo

0.00

BR 10-02-09

(X) LH 0

Hand Finishing

10/02/09

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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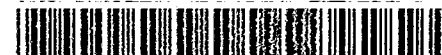
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Cust Item ID:

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Per 10/2/18 (1)

230

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

*PR**Per 10/2/18*

240

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/02/18**MF**10-2-18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 54963

Parent Item: D3562-041

Parent Item Name: Step Assembly, LH



Comments:

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Re To Pick	Qty Issued	Date Issued	Status
D2734		Manufactured	No			100	Each	25.0000	2.0000			
												
Step End Plate												

10-01-15

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	25	
43535	2	
48110	23	

2

D2622-120C

Manufactured No



Step Extrusion

140	Each	84.8200	1.0000
			

10-01-18

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	84.82	
48612	3.12	
52026	81.7	


1

D3560-041

Manufactured No



Arm Weldment

140	Each	2.0000	1.0000
			

10-01-15

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
47863	2	

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January 5, 2010 11:19:17 AM

Work Order ID: 54963



Parent Item: D3562-041



Parent Item Name: Step Assembly, LH

Start Date: 05/01/2010

Required Date: 18/01/2010


Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3560-043		Manufactured	No			140	Each	1.0000	1.0000			
Arm Weldment												

PK 10.01.15

<u>Warehouse</u>				<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>					
Main Warehouse					
ST				1	
<u>47865</u>				1	
MS20600-AD4W5	Purchased	No		160	Each
				852.0000	32.0000
Blind Rivet					

1

PK 10.01.18

Warehouse		Loc Qty	Loc Code
Location			
Main Warehouse			
ST		852	
110523		212	
111477		640	

32

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

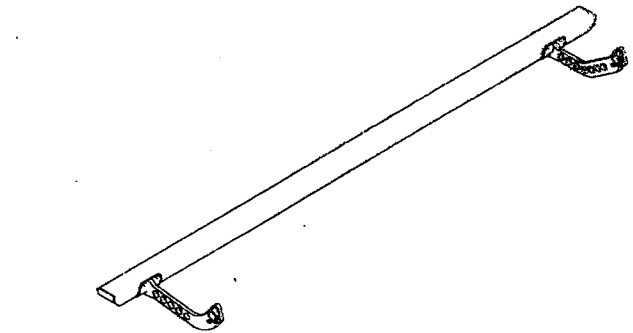
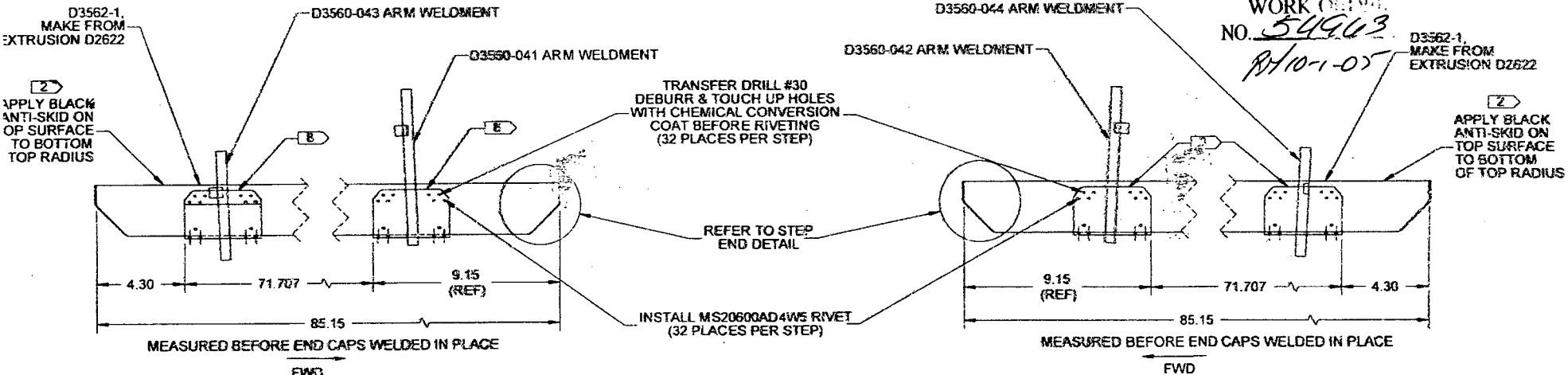
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

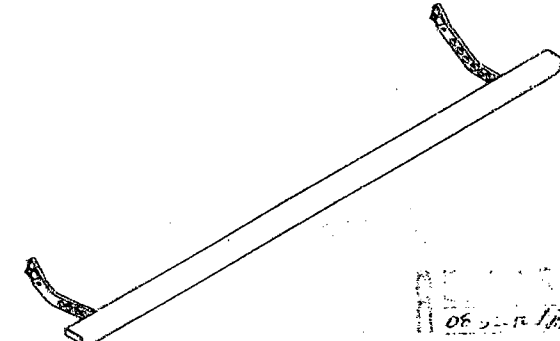
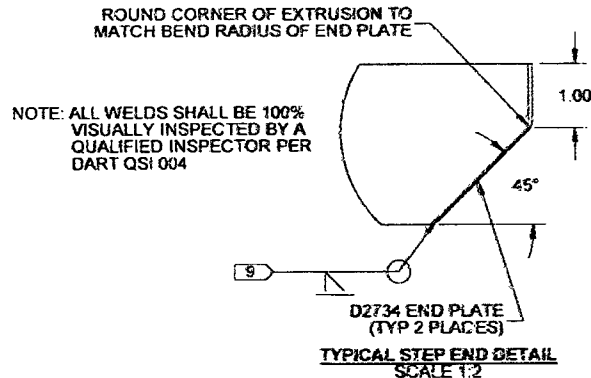
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NOTE: Date & initial all entries

WITHOUT NOTICE
WORK ORDER
NO. 54903
R/10-1-05



D3562-041 LH STEP ASSEMBLY



D3562-042 RH STEP ASSEMBLY

- NOTES:
- MATERIAL: N/A
 - FINISH:
 - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
 - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
 - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 - TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - UNITS: INCHES UNLESS OTHERWISE NOTED
 - BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - IDENTIFICATION: NONE
 - WEIGHT: 8.79 lbs
 - INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
 - WELDING: PER DART QSI 004

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3562-041	LH STEP ASSEMBLY
	X	D3562-042	RH STEP ASSEMBLY
1		D3560-041	ARM WELDMENT
	1	D3560-042	ARM WELDMENT
1		D3560-043	ARM WELDMENT
	1	D3560-044	ARM WELDMENT
32	32	MS20600AD4W5	RIVET
2	2	D2734	END PLATE

E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
G	REMOVE D2808 SPACER NOTE; REDRAWN IN SOLIDWORKS	QC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.28
REV.	DESCRIPTION	BY	DATE
DESIGN	gp	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3562 TITLE STEP ASSEMBLY SCALE 1:5 <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	kg		
CHECKED	ie		
MFG APPR.	MD		
APPROVED	MD		
DE APPR.	MD	DATE 08.01.11	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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